

Work Order ID: 73441



Page 1

Thursday, September 01, 2011 7:24:13 AM

Item ID:	D4055-7	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Tank Fwd End					
Start Date:	8/31/2011	Start Qty:	3.00		Cust Item ID:	
Required Date:	9/16/2011	Req'd Qty:	3.00		Customer:	
Reference:						

Approvals:	Process/Plan:	CL	Date:	11/09/01	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4055	B								

100		0.00							
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	Waterjet	Memo	0.00	B11-11-21						
FLOW CNC Waterjet		Cut as per dwg D4055								
6061 . 063		Prog rev: <u>B</u>								
		Dwg rev: <u>B</u>								

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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	QC	Memo	0.00	D11-11-21						
Quality Control										

120	QC8- Inspect parts - second check	0.00							
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	QC	Memo	0.00	11 . 11 . 22 (3)						
Quality Control										

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 73441**

Thursday, September 01, 2011 7:24:13 AM



Page 2

Item ID: D4055-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Fwd End

Start Date: 8/31/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

Bend 18 - 20 degrees

SB 12/02/08

(3)

140

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

S 12/02/09

(x3)

141

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

3 BL 12-2-10.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73441



Page 3

Thursday, September 01, 2011 7:24:13 AM

Item ID: D4055-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Tank Fwd End

Start Date: 8/31/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

142

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

3x of all 12/02/10  
counted & identified

150

Identify as per dwg & Stock Location: WFA

0.00



Packaging

Memo

0.00

Packaging

12.02.10 3  $\phi$

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

12/2/13  
MF  
12-02-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, September 01, 2011 7:24:11 AM

Page 1

Work Order ID: 73441

Parent Item: D4055-7

Parent Item Name: Tank Fwd End



Start Date: 8/31/2011



Required Date: 9/16/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM  
10.11.23 now made in house DD verf:EC

IPP rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4055-7P 		Purchased	No				Each	0.0000		3			
Tank Fwd End													
M6061T6S.063 		Purchased	No			100	sf	205.1256	3.12	9.852632			
6061-T6 .063 Sheet													

Location

Loc Qty

Loc Code

MAT021

205.1255684

116308

26.9755684

117285

105.15

118580

73

119331

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

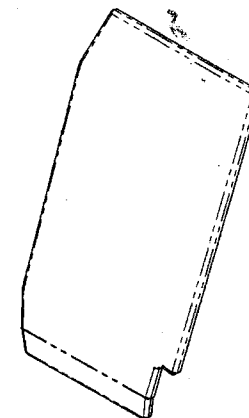
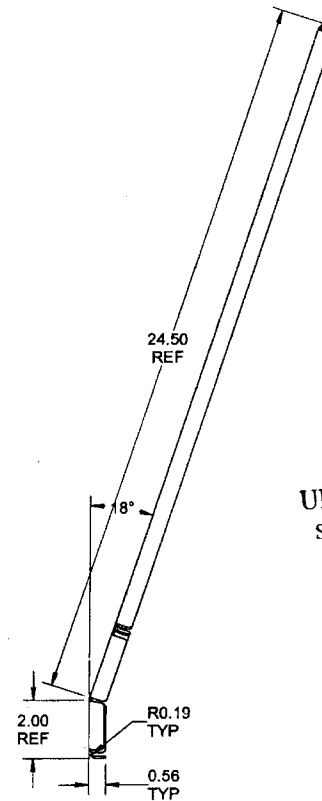
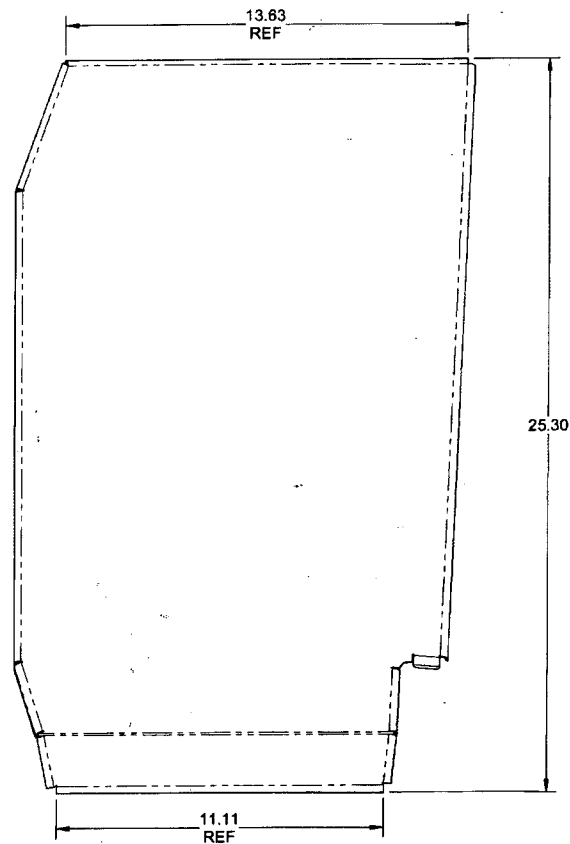
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries







SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 73941  
CL11/09/01

RELEASED  
2011-05-30  
JN

**D4055-7 TANK FORWARD END**

**NOTES:**

- 1) MATERIAL: MADE FROM D4055-7F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs



DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4055</b>	REV. B
MFG. APPR.		SHEET 10 OF 15	
APPROVED		TITLE <b>TANK</b>	SCALE NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DATE	11.05.12	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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C

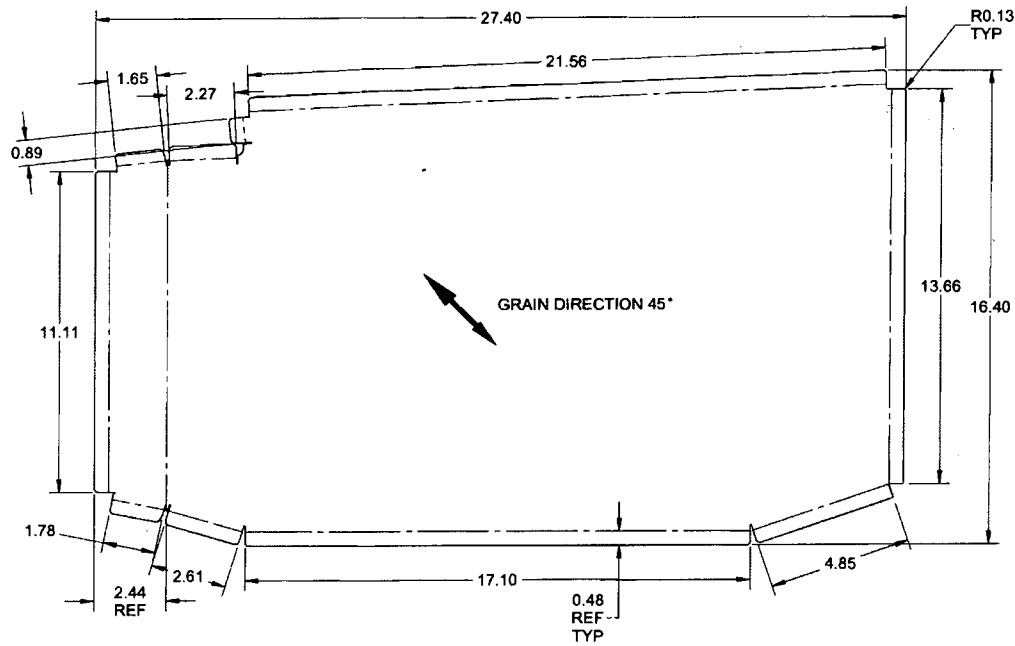
B

D

C

B

0.063  
REF



**D4055-7F FLAT PATTERN**

**RELEASED**  
2011-05-30  
JW

**NOTES:**

1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 2.56 lbs

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